



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE117-68021W10
Job Sheet 185112



Part No: RBE117-68021W10

Job Qty: 1 ea

Part Name: Pusher



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/23/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE117-68021W10 Rev. 1 IPP Rev. A 18.09.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/30/18	11/30/18	0.00	0.00	Start Up Machining-2		JB 18-12-12
110	CNC Lathe	4 pcs	11/30/18	11/30/18	0.00	1.00	MORI SL-154		JB 18-12-17
120	QC	4 pcs	11/30/18	11/30/18	0.00	0.00	QC2 Machining-4		JB 18-12-17
130	QC	4 pcs	11/30/18	11/30/18	0.00	0.00	QC8 Machining-4		JB 19-01-06
150	Outsource	4 pcs	11/30/18	11/30/18	0.00	0.00	Outsource12		CB 18-01-06
160	Packaging	4 pcs	11/30/18	11/30/18	0.00	0.00	Packaging2		CB 18-01-06
170	QC	4 pcs	11/30/18	11/30/18	0.00	0.00	QC6		CB 18-01-06
180	Packaging	4 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3-1		CB 18-01-06
190	QC21-SA	4 Ea	11/30/18	11/30/18	0.00	0.00	QC21		CB 18-01-06

Part Op 110 - 1-Machine as per DWG. FC420 FOLIO REV: AA DWG REV: 1 2-Deburr
Descriptions: 150 - -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.750	AISI 4140 Quenched & Tempered Steel Round Bar 1.750" Dia.	.9800 ft (.245 ea)	90-Start up Operation	5048045

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140QT-R1.750	1	16	0

Part Specifications

ould not be found.

Plex 10/23/18 7:40 AM Dart.lajeunesse.marie



Container No: S137495



Part: RBE117-68021W10

Job No: 185112

Serial No/Batch: S137495

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/12/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

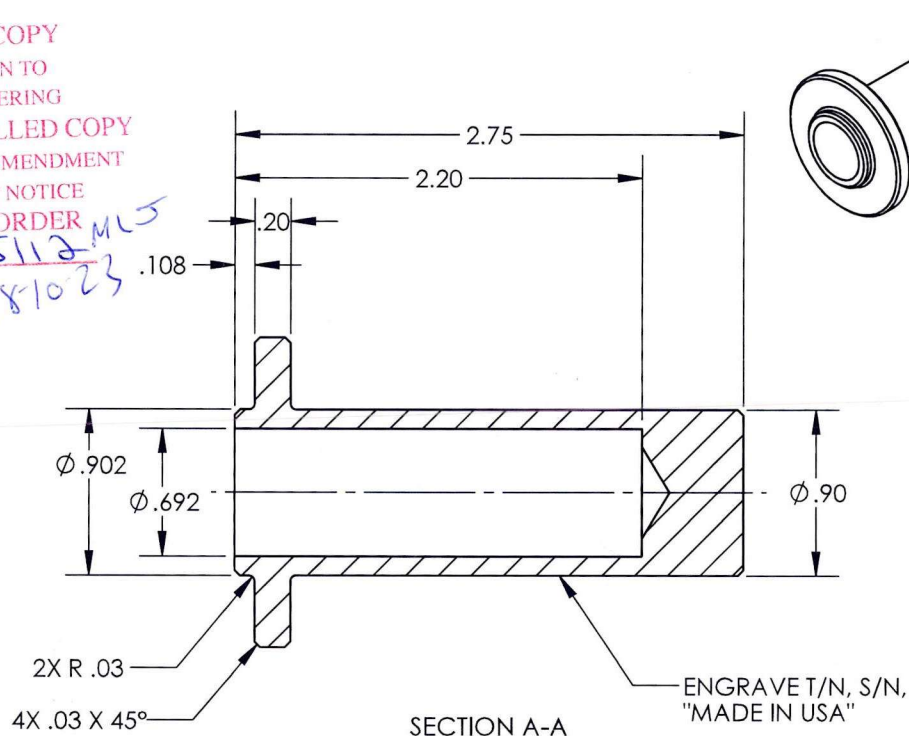
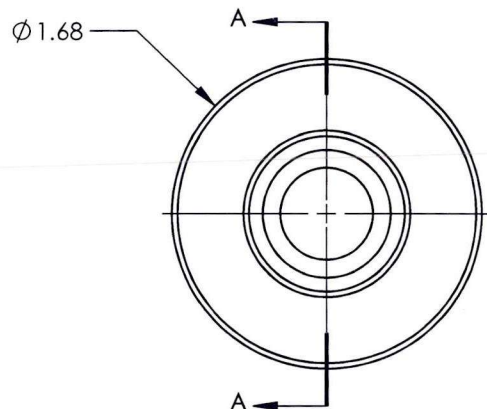
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	9/6/2016	DPD	JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185112 ML5
181023



SECTION A-A

NOTE:
REF. AIRBUS T/N: 117-68021W10.

DART AEROSPACE	
TITLE PUSHER	
DWG NO. RBE117-68021W10	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/ 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
HEAT TREAT RC 28-34	
FINISH BLACK OXIDE	
SPEC QMSI-6.2.2, B.O. REV D	
DRAWN BY: DUERFELDT	
CHECKED: CLOUGH	QA APPR: LINDSAY
OPPS APPR: ANDERSON	APPROVED: GILBERT
SCALE 1:1	
DATE 7/20/2016	SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
				1	PUSHER	4140/4142	

DART AEROSPACE LTD	Work Order:	185112
Description: Pusher	Part Number:	RBET1768021W10
Inspection Dwg:	Rev: 1	Page 1 of 1

[illegible]

Measured by: JB	9-89	Checked by: <i>[Signature]</i>	QC Inspector:
Date: 18.12.17		Date: 19/01/06	Date:

Engineering Approval: (If necessary)			Date:	
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

Revised by	Approved
KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042174



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042174
PO Date: 1/7/19
Due Date: 1/14/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185112	RBE117-68021W10	Pusher -Issue P/O to GROUPE ALTECH; PO -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	1/14/19	6 pcs	0 pcs	6 pcs	\$20.00/pcs	\$120.00
Grand Total:											\$120.00

JAN 11 2019

DAS
38
9-89



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042174



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/7/19 8:39 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(015727-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

015727 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
09-Jan-2019		Aman		042174					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBE117-68021W10 Rev.	RBE117-68021W10 01 - BLACK OXIDE ON SST MIL-DTL-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	OXIDE-BLACK CH	6	6	0	0	0	

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.